



PRODUCT DATA SHEET

PTW-582 WATER REDUCIBLE EPOXY PRIMER

PTI EPOXY PRIMER SERIES

DESCRIPTION

PTW-582 Water Reducible Epoxy Primer is chemical and solvent resistant. It is a TUF/FILM epoxy primer that conforms to MIL-PRF -85582D. It is especially recommended to inhibit corrosion of aluminum and other plated or unplated metallic surfaces. PTI's Water Reducible Epoxy Primer is recommended for all PTI topcoats to provide maximum adhesion and corrosion protection.

COLORS

This coating can be provided in light green, dark green and BMS colors.

COATING PROPERTIES & CHARACTERISTICS

Mix Ratio, by volume	4 part Base to 1 part Catalyst
Reducer	Distilled Water
Recommended Dry Film Thickness	0.6 – 0.9 mil
Admixed Viscosity	14 seconds, max #4 Ford
Admixed Weight per Gallon	12 lbs.
Theoretical Coverage	800 sq. ft./gal.
Pot Life	6-8 hours
Coatings VOC	190 g/L

SHELF LIFE

Shelf life is only applicable for materials stored in unopened and undamaged original factory filled containers. 1 year when stored between 50°-85° Fahrenheit.

MIXING INSTRUCTIONS

Shake component A in a paint shaker for 5 – 10 minutes for optimal results.
Admix by volume:

For a Viscosity of 22 seconds in a #2 Zahn:

4 Parts Component A (Base)
1 Part Component B (Catalyst)
1 Part Distilled Water (Reducer)

For a Viscosity of 18 seconds in a #2 Zahn:

4 Parts Component A (Base)
1 Part Component B (Catalyst)
2 Parts Distilled Water (Reducer)

Add the Catalyst into the Base.

Admixed material should be allowed a 45-minute induction time for best application results.

Reduce: Use distilled water to thin or reduce the primer according to the instructions above. **DO NOT OVER THIN THIS MATERIAL.**

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APPLICATION

This product can be applied by brushing, rolling or using conventional air or HVLP spray equipment. Please consult with a PTI representative for specific equipment recommendations and settings.

1. Make sure pots, guns, and lines are purged and cleaned.
2. Mix both base and catalyst thoroughly and filter/strain before spray application.
NOTE: It is not recommended to strain flat/matte coatings.
3. HVLP spray pressure: 7-10psi. Conventional spray pressure 15-30psi
4. Always air-blow and tack wipe the surfaces to be painted. Aircraft should be grounded to prevent static.
5. Best application results: apply 2 coats: 1 fog/tack coat & 1 full coats from 0.6 – 0.9 mil thickness.
6. Do not allow more than 24 hours to pass before applying the second coat.
7. Recommended Dry Film Thickness is 0.6-0.9 mils. Some colors may require thicker films to achieve hiding.

NOTE: Application of PTI products requires the use of all OSHA approved safety equipment, including proper ventilation. Additionally, PTI products require the recommended temperature/humidity conditions and film thickness ranges for optimal performance. The material, hangar, and aircraft skin temperatures should be no lower than 75° F / 25° C before, during and after application.

DRYING & CURING SCHEDULE

Dry times are based on the dry film thickness between 0.6 - 0.9 mils (25-50 microns).

Air Cure:

Tack Free 60 minutes maximum

Dry Hard 6 hours maximum

Force Cure:

Tack Free ½ hour @ 150F

Dry Hard 1 hour @ 150F

Always bring the coating to the “tack free” stage before top coating.

- If using PTI additives to adjust the dry and cure times of the coating, please refer to those Product Data Sheets for specific instructions for admixing the material.

EQUIPMENT CLEANUP

Use clean PT-1003 Type I Reducer. Do not allow material to dry or cure inside any equipment.

HEALTH, SAFETY, & STORAGE REQUIREMENTS

Refer to each individual material SDS (Safety Data Sheet) for specific requirements on the health, safety, storage and handling requirements. Follow all local, state, and national regulations during surface preparation, material application and cleanup.

PRODUCT INFORMATION & DISCLAIMER

Product Data Sheets are periodically updated to reflect new information. It is important to use the latest and most recent revision for the product being used. The foregoing information is accurate to the best of our knowledge. However, due to differences in customer handling, use and method of application which are not known and are beyond our control, Products Techniques, Inc. makes no warranties as to the end result.